

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.21**WELDING WITNESS REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WWR-000206**Date Inspected:** 18-May-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**Location:** Shanghai, China**Witness:** **Procedure Qualification Record**  
**Welding** **NDT****Welder Qualification**  
**Mechanical Testing, describe:****Fracture Critical****Index Lot #:** B49-025-07**Bridge No:** 34-0006**Welder:** Xiang Jie**Witness Lot #:****Component:****ID #:****Joint Description:** B-U2a-GF

N/A

**WPS ID #:**

PWPS-B-T2241-U-2

N/A

**Base Metal:** A709M Gr345T2

N/A

**PQR ID #:**

HP200783

N/A

**Thickness:** 26mm

N/A

**Process:**

GMAW

N/A

**Electrode Spec/Class:** A5.18/ER70S6 (JM-56 1.4 dia.)

N/A

**Positions:**

1G

N/A

**Backing Material:** A709M Gr345T2

N/A

**CWI:**

Wei Huang

N/A

**Average Amps:** 357.0

N/A

**AWS Code:**

AWS D1.5 2002

N/A

**Average Volts:** 30.9

N/A

**Applicable Sec:**

5.13

N/A

**Travel Speed:** 545.9

N/A

**Heat Input:**

1.21 KJ/mm

N/A

**Preheat:** 20 degrees Celsius

N/A

**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector was present as requested to witness the welding of a procedure qualification (PQR) test plate identified as HP200783. The welding was performed in accordance with AWS D1.5 2002, Section 5.13 requirements. The gantry type welding machine identified as, Power Wave 455M CE. The welding appeared to comply with the project documents. The completed weld test was visually inspected and visually accepted by ZPMC QA Inspector, Mr. Wei Huang and accepted for conformance per AWS D1.5 2002 requirements.

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## WELDING WITNESS REPORT

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### Summary of Conversations:

As identified within the contents of this report.

### Observed welding, testing or results:

is in general conformance with the contract requirements.

is not in conformance with the contract requirements.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hasler, Mike	Quality Assurance Inspector
<b>Reviewed By:</b>	McClary, David	QA Reviewer

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